

Work Order ID 75605

75605

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Wednesday, October 26, 2011 2:01:03 PM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Collective Lock Assembly
 Start Date: 10/26/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/27/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

UNALIK

Approvals: Process Plan: *MF* Date: *11-10-26* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								

100
100
 Small Fab
 Small Fab
 Small Fab
 Memo
 Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
 Identify as D3372-3

0.00

0.00

SB 11/10/27 (1)

110
110
 QC
 Quality Control
 QC5- Inspect part completeness to step on W/O

0.00

0.00

SB 11/10/27

(1)

120
120
 Small Fab
 Small Fab
 Small Fab
 Memo
 1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
 lock barrel. Discard the rest.
 2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
 D3369-5

0.00

0.00

SB 11/10/27

(1)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads								
	Qty Part Number Description Batch								
	A/R N/A Locktite 262 <u>11112</u> 951								
	Identify as D3372-053								
	2-Assemble D3372-051 as per Dwg								
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Tack weld lock shaft as per Dwg D3372								
	A/R SS Rod Batch <u>1114509</u>								

SP 11/10/27

EL 11-10-27 (X1)

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Packaging

Number Stamp
11/10/27 
ME
11-10-27

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IPP Rev:C added D3384-043 DD

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	2,554.0000	2	2		5/11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST377		2554							
				115072		79							
				115174		53				2			
				116643		261							
				117332		1161							
				119343		1000							
AN5-42A Bolt		Purchased	No			100	Each	20.0000	1			5/11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST340		20							
				108442		20							
AN960-416 Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2			5/11/10/27	
D2728-7 Dart Logo label		Manufactured	No			100	Each	0.0000	0			5/11/10/27	
D3372-1 Main Body		Manufactured	No			100	Each	2.0000	1			5/11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2		B 75124		1			
				70038		2							
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	3.0000	1	1		5/11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST048		3							
				70035		3							

Picklist Print

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Work Order ID: 75605

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 10/26/2011

Required Date: 10/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3372-7 Manufactured No 100 Each 3.0000 1
Slider Body

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST492	3	
69633	1	
70036	2	

D3373-1 Manufactured No 100 Each 25.0000 1
Cam Lock

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST049	25	
58463	5	
74862	20	

D3384-043 Manufactured No 100 Each 7.0000 1
Cyclic Sock Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST480	3	
74729	3	
ST486	4	
70037	4	

HX-81 Purchased No 100 Each 17.0000 1
1/4"-20 SHCS 3/8" long

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST390	17	
114383	17	

EP 11/10/27

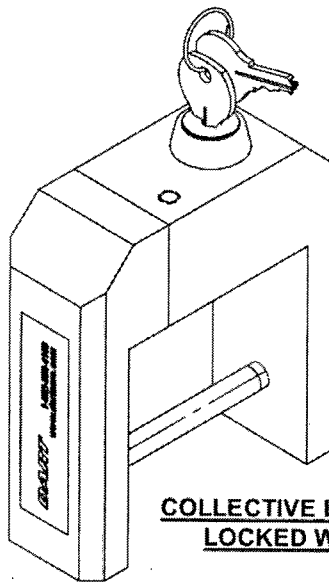
EP 11/10/27

EP 11/10/27

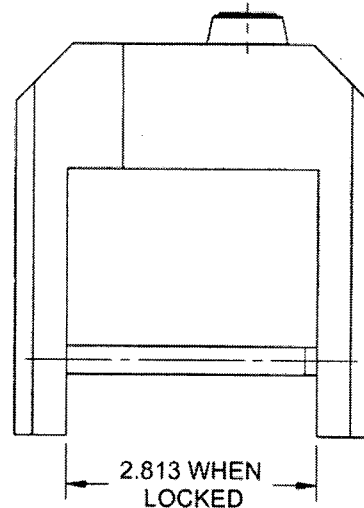
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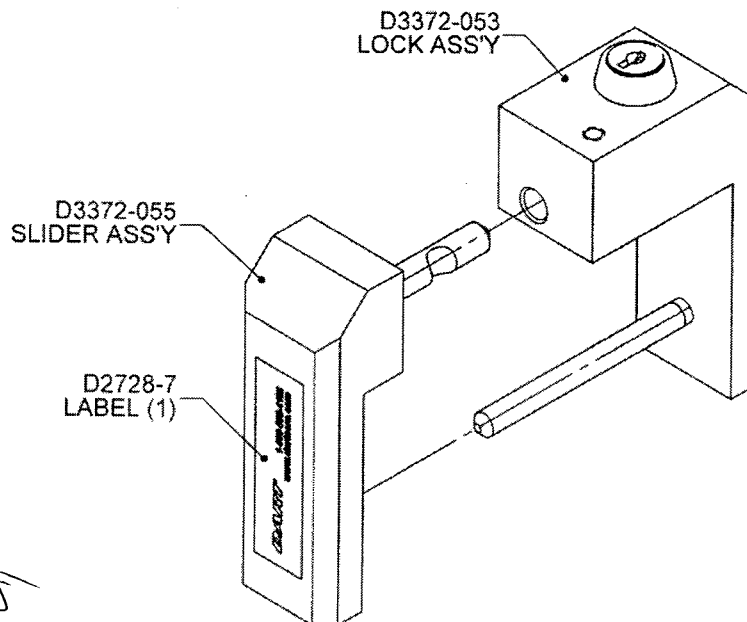
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



2.813 WHEN
LOCKED



RELEASED
05/04/28

\$75605

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

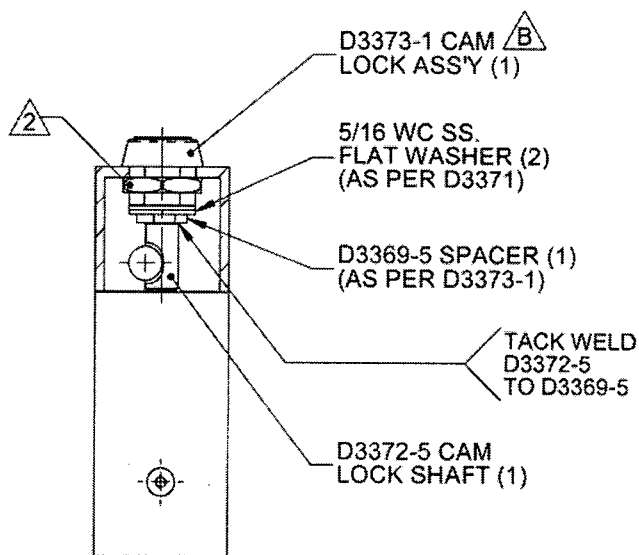
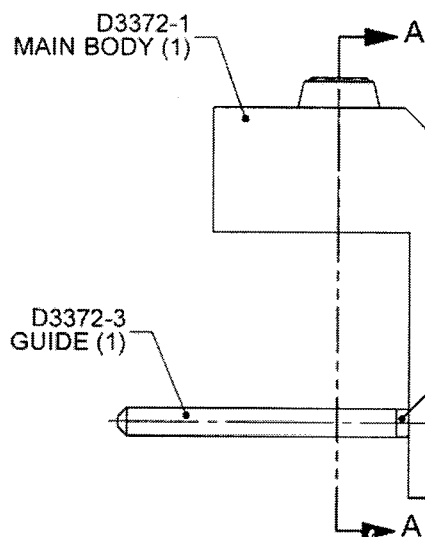
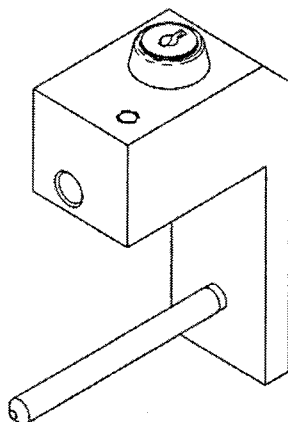
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

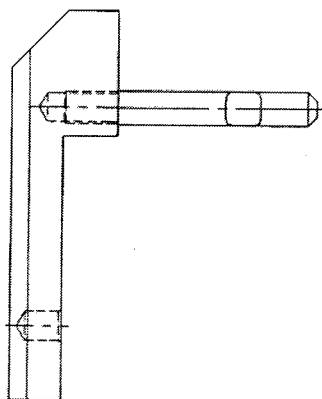
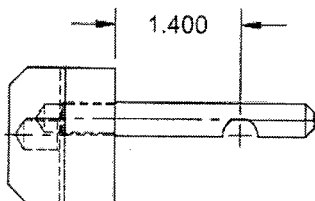
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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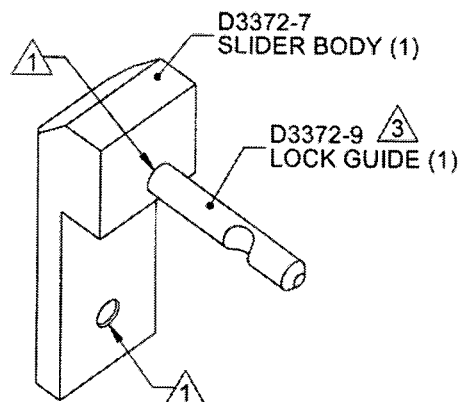
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



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D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

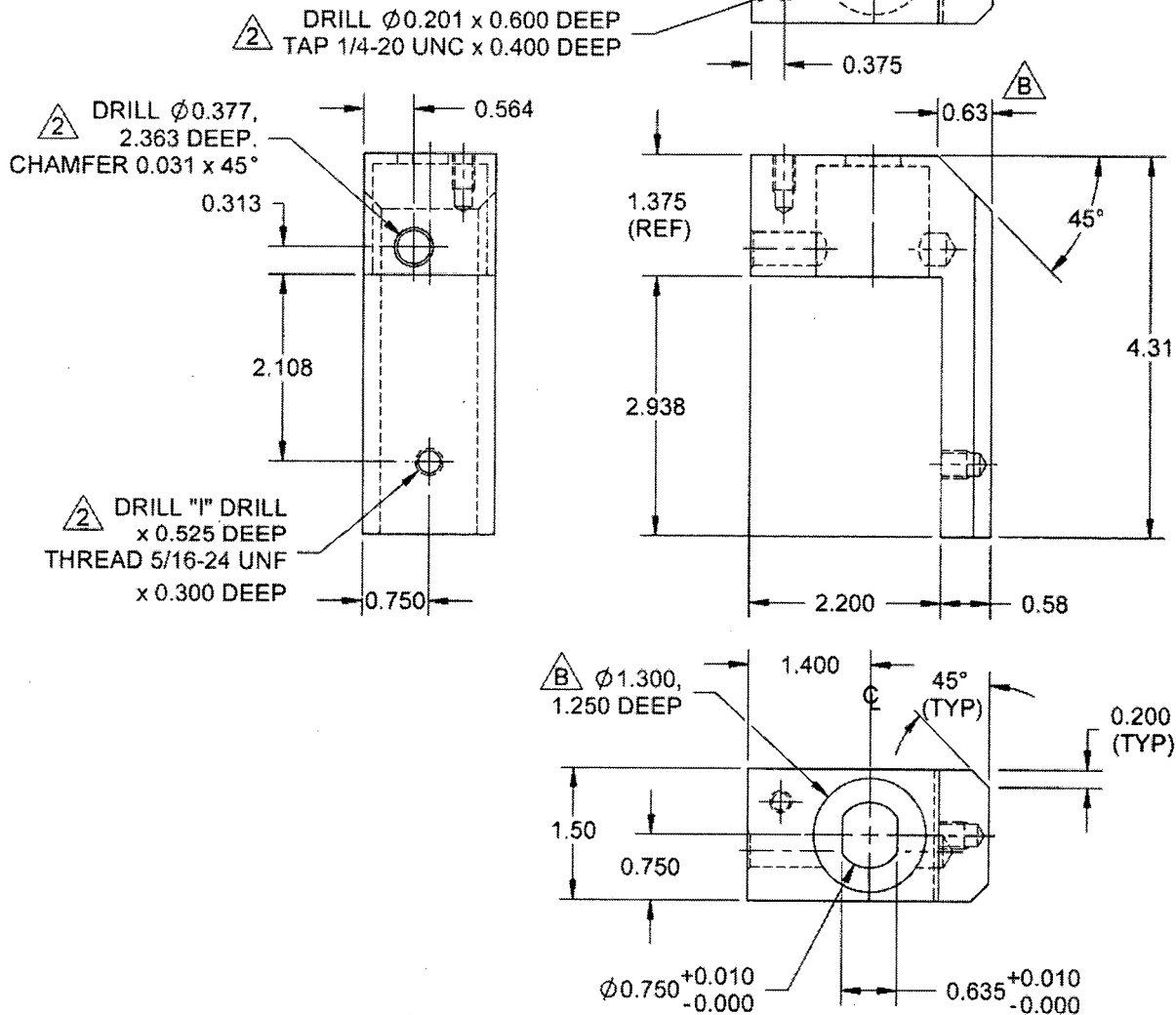
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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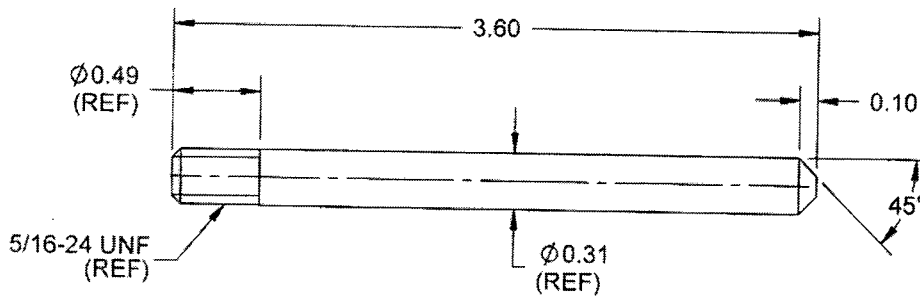
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

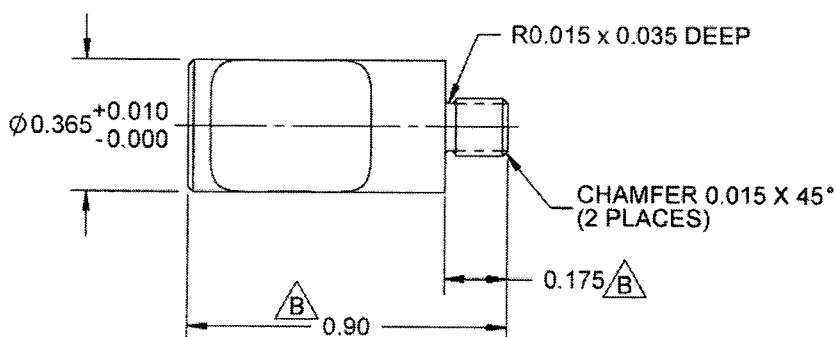
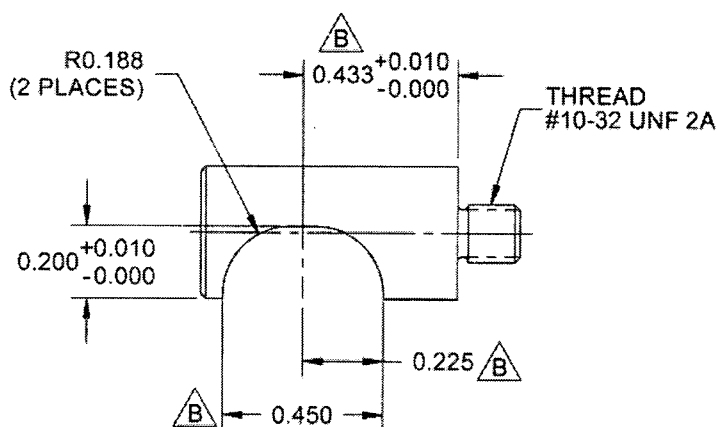
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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D3372-5 CAM LOCK SHAFT

NOTES:

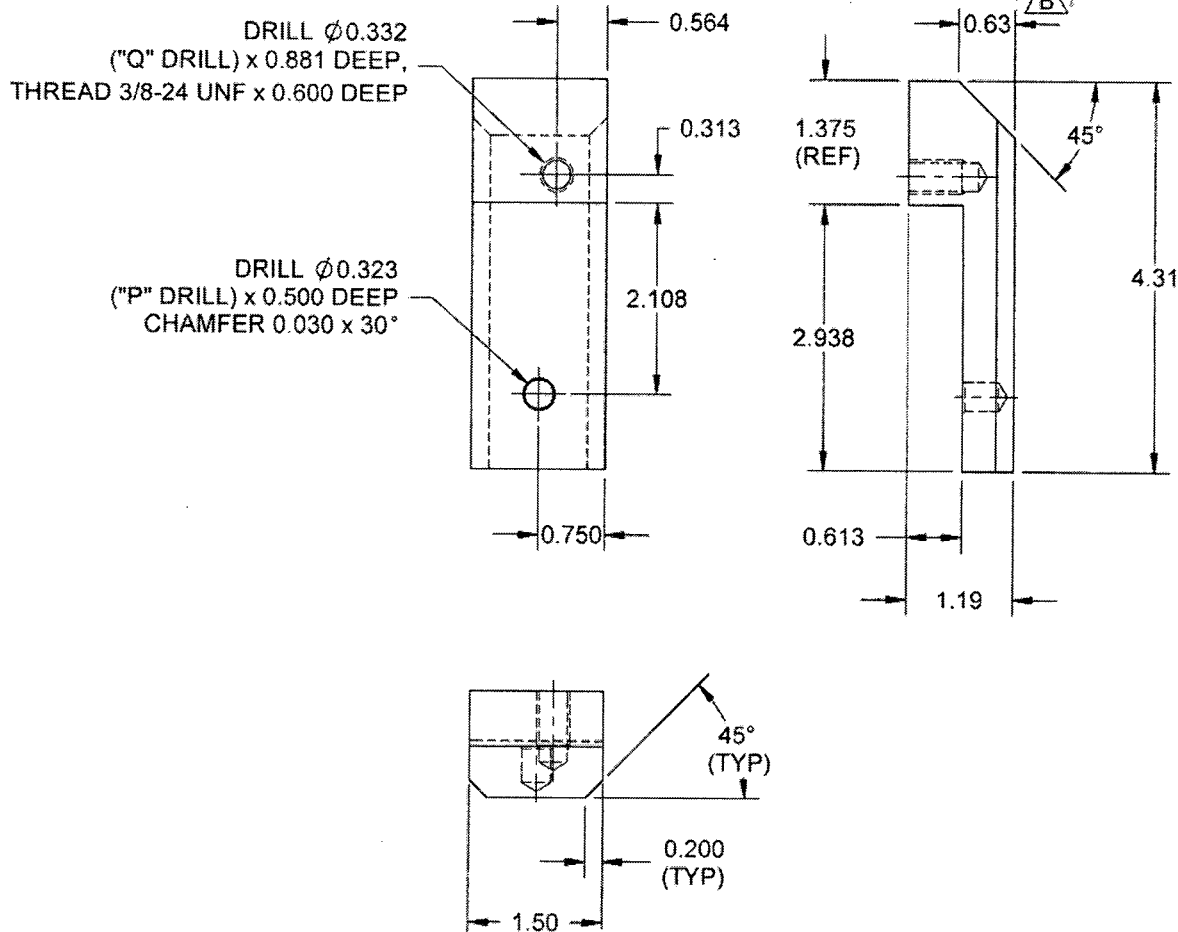
- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

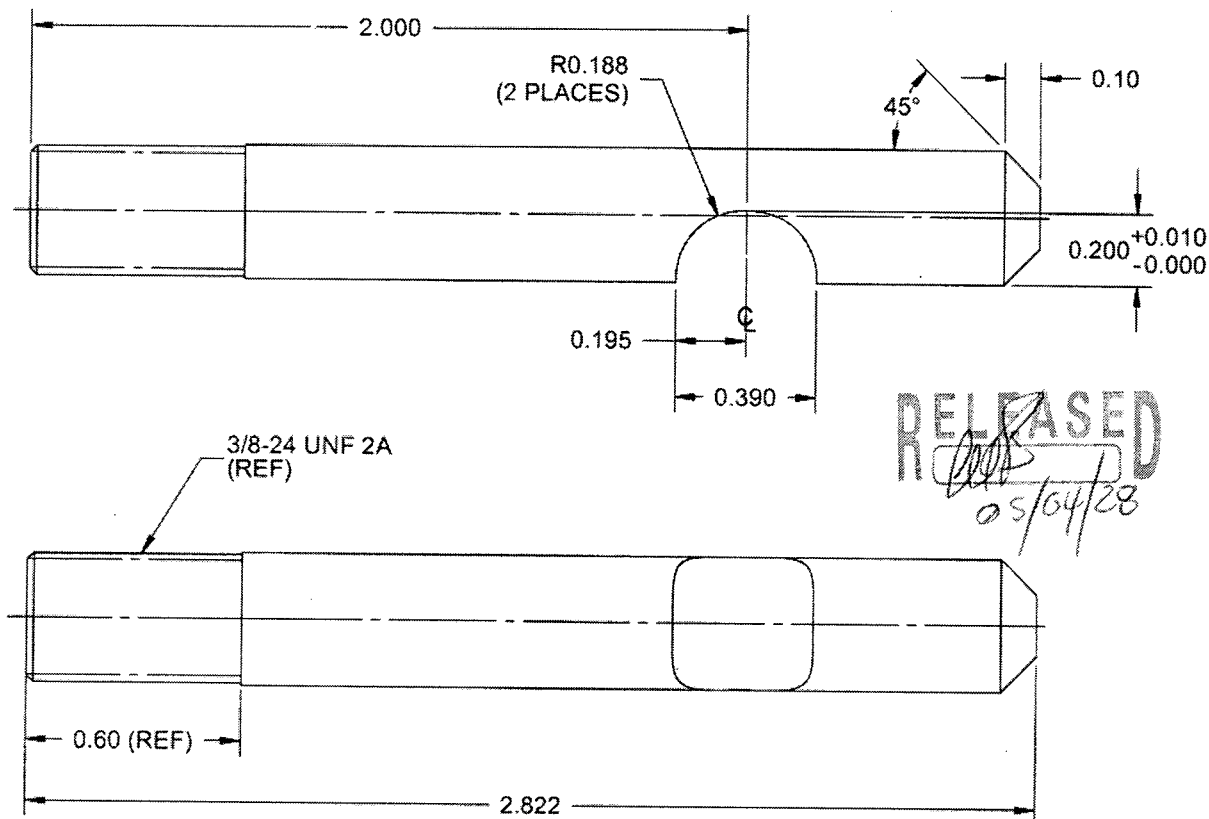
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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